

Work Order ID 84003 - 2

Mxy-01-12 10:38:15 AM

84003

Page 1

Item ID: D119-675-012

Revision ID:

Item Name: Heli-Access-Step RH

Start Date: 01/05/2012 Start Qty: 4.00

Required Date: 15/05/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MJS

Date: 12/05/01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev N/A
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100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP 119-675-012 CHG004

JB S. 7/6/03

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

3

12/06/15 JB

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

S. 7/6/03

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D119-675-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step RH

Start Date: 01/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-012
Location: _____

12/7/3 (B)

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/7/4

MF
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 84003

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3043-042

Manufactured

No

110

Each

0.0000

1

4

D3043-042

Step Weldment RH, A119

D2182B032

Manufactured

No

110

Each

14.0000

4

16

D2182B032

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

14

63469

4

73932

10

73932

D2274

Manufactured

No

110

Each

632.0000

8

32

D2274

Radius Block

Location

Loc Qty

Loc Code

ST007

632

78233

22

81958

400

83258

210

81958

D2617-3

Manufactured

No

110

Each

20.0000

4

16

D2617-3

Bushing

Location

Loc Qty

Loc Code

FG

10

27991

10

ST012

10

76948

10

24008

12/06/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84003

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D2617-5 Manufactured No

110 Each 21.0000 8 32

D2617-5

Spacer

** 22x 84007

Location

Loc Qty

Loc Code

FG

10

31756

10

ST012

11

81814

11

110 Each 0.0000 1 4

D2732-032 Manufactured No

D2732-032

RUBBER CUSHION

D3041-1

Manufactured No

110 Each 23.0000 4 16

D3041-1

Clamp

** 70787 JB

** 94 84000 JB

Location

Loc Qty

Loc Code

ST462

23

77050

1

79723

22

110 Each 24.0000 2 8

D3041-3 Manufactured No

D3041-3

Clamp

ix 77050
ox 79723

** JB

Location

Loc Qty

Loc Code

ST462

24

51114

8

76997

16

110 Each 20.0000 4 16

D3042-1 Manufactured No

D3042-1

Clamp

76697

** 12x 83999

Location

Loc Qty

Loc Code

ST457

20

77487

20

4x 77487

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84003

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-11A

Purchased

No

110

Each

244.0000

4

16

**

AN4-11A

Bolt

Location

Loc Qty

Loc Code

ST356

244

118706

94

120731

100

121243

50

118706

AN4-12A

Purchased

No

110

Each

667.0000

8

32

**

AN4-12A

Bolt

Location

Loc Qty

Loc Code

ST357

667

115422

4

119775

50

120423

588

121524

25

120423

AN4-15A

Purchased

No

110

Each

539.0000

4

16

**

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

439

118706

3

119449

1

119749

19

120422

116

121444

100

121541

200

121541

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84003

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

84003

D119-675-012

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased

No

110

Each

30.0000

12

48

**

121912 JB

SL

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

5,520.000

12

48

**

JB

SL

12/06/15

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.5 lb	- 32.4 in	- 373 in-lb	121.3 in	1395 in-lb
HELI-ACCESS-STEP™, LH	5.2 kg	- 1.28 m	- 6.7 m-kg	3.08 m	16.0 m-kg
D119-675-012	11.5 lb	+32.4 in	+373 in-lb	121.3 in	1395 in-lb
HELI-ACCESS-STEP™, RH	5.2 kg	+1.28 m	+6.7 m-kg	3.08 m	16.0 m-kg

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELI-ACCESS-STEP™, LH
	X	D119-675-012	HELI-ACCESS-STEP™, RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Date: 07.10.23